

Work Order ID 57415

April 6, 2010 3:22:48 PM

BLACK

shp 13/04



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002
NON-EUROCOPTER

8.10.13

10/04/12

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/R ☐ Aluminum Rod

1111311
1114242

3-Grind End Plate flush

10.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57415

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Item ID: D350-591-311

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Required Date: 4/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							① PD 10.04.07
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							S 10.04.07
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10.04.07

Handwritten signature/initials in a circle.

Handwritten signature/initials.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R□□Aluminum Rod□ M111311

6-Grind End Plate flush

7-Install last rivet as per Dwg.

SAD
10-04-07

①

PH 10-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-591-311

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Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M 105642

Powdercoat

Memo

0.00

Powder Coating

ATTN: POWDER COAT BLACK SANTEX PER QSI 005

⇒ M 10/04/09

(X1) Ø

START TIME: 10:15 AM
OVEN TEMPERATURE: 370°F
FINISH TIME: 10:45 AM

230

Wing Walk as per dwg QSI005 4.4 Batch M113545

0.00



HandFinish

Memo

0.00

Hand Finishing

10-4-12

Ø 1/4" Ø

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/4/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D350-591-311

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Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/13

PS 10-4-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 57415

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3065-041		Manufactured	No				Each	14.0000	1.0000			
												
Step Leg Assembly Hi												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

14

55450

14

Each

44.0000

2.0000

D3066-1

Manufactured

No



Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

44

56752

44

Each

65.0000

2.0000

D3219-1

Manufactured

No



Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

65

56826

65

10.04.07

1
10.04.07

2
10.04.07

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 57415

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D350-591-311		Manufactured	No				Each	2.0000	1.0000			
Step Modification	CHG001									57368		

Warehouse		Loc Qty		Loc Code	
Location					
Main Warehouse					
FG		2			
57038		2			
D3067-1	Manufactured	No	110	Each	29.0000
End Plate					1.0000

10.04.07

Warehouse		Loc Qty		Loc Code	
Location					
Main Warehouse					
WA		29			
57011		29			
D3272-1	Manufactured	No	110	Each	0.0000
Step					1.0000

357417 10.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/06/10

Required Date: 4/12/10



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L5		Purchased	No			110	Each	401.0000	21.0000			
												
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST300	401	
113523	26	
113537	175	
114108	200	



M113537

MS20600-AD4W4	Purchased	No				180	Each	979.0000	16.0000			
												
Rivets												

10.04.07

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST321	979	
113368	479	
114181	500	

16

AN3-35A	Purchased	No				260	Each	56.0000	2.0000			
												
Bolt												

10/4/12

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST353	56	
112314	56	

M112314

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W/O:		WORK ORDER CHANGES					
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IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-13A		Purchased	No			260	Each	47.0000	8.0000			
Bolt												

M114330 4x

Warehouse Location

Main Warehouse

ST357

47

114181

40

4828

7

M114181 4x

AN5-36A		Purchased	No			260	Each	165.0000	2.0000			
Bolt												

Warehouse Location

Main Warehouse

ST341

165

114292

165

M114292

AN960JD10		Purchased	No			260	Each	0.0000	4.0000			
Washer												

M114292

AN960JD416		Purchased	No			260	Each	0.0000	16.0000			
Washer												

M113706

AN960JD516		Purchased	No			260	Each	0.0000	4.0000			
Washer												

M113706

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2230-3		Manufactured	No			260	Each	153.0000	4.0000			
												
Lug												

Warehouse
Location

Main Warehouse

ST476

153

56855

153

260

Each

49.0000

2.0000

56855

D2618

Manufactured

No

Bushing

Warehouse
Location

Main Warehouse

ST020

49

56892

49

260

f

235.5600

0.6000

56892

D2856-400

*7.20"

+2 per

Manufactured

No

Abraison Strip

Warehouse
Location

Main Warehouse

ST403

235.56

50593

-1.2

52563

20.76

56626

216

50593

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3067-1		Manufactured	No			260	Each	29.0000	1.0000			
											10.04.07	
End Plate												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

29

57011

29

Manufactured No

260

Each

27.0000

2.0000

D3235-1



Mounting Lug

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST471

27

55315

27

Manufactured No

260

Each

25.0000

1.0000

D3278-041



Support Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST471

25

55318

25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 57415

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


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IPP Rev:B 07-06-09 Added D3272-1 JLM
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Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			260	Each	1,371.000	2.0000			
												
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300	1371
113537	387
113644	984

MS21042L4

Purchased

No

260

Each

1,590.000 8.0000



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST139	2
111827	2
Main Warehouse	
ST300	1588
113422	580
114108	1000
9063	8

M113537

M113428

LC 1/4/12 (1)

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

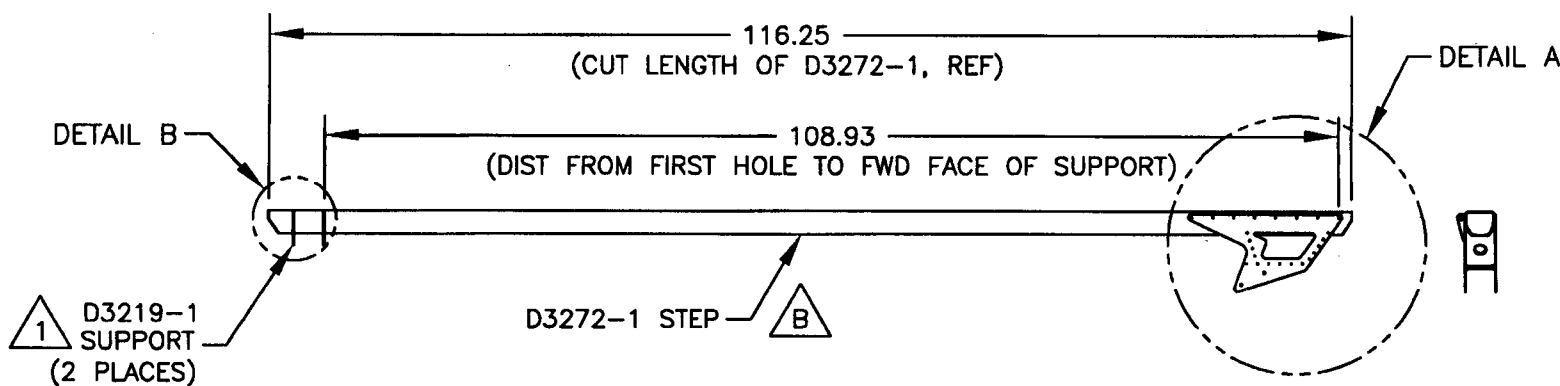
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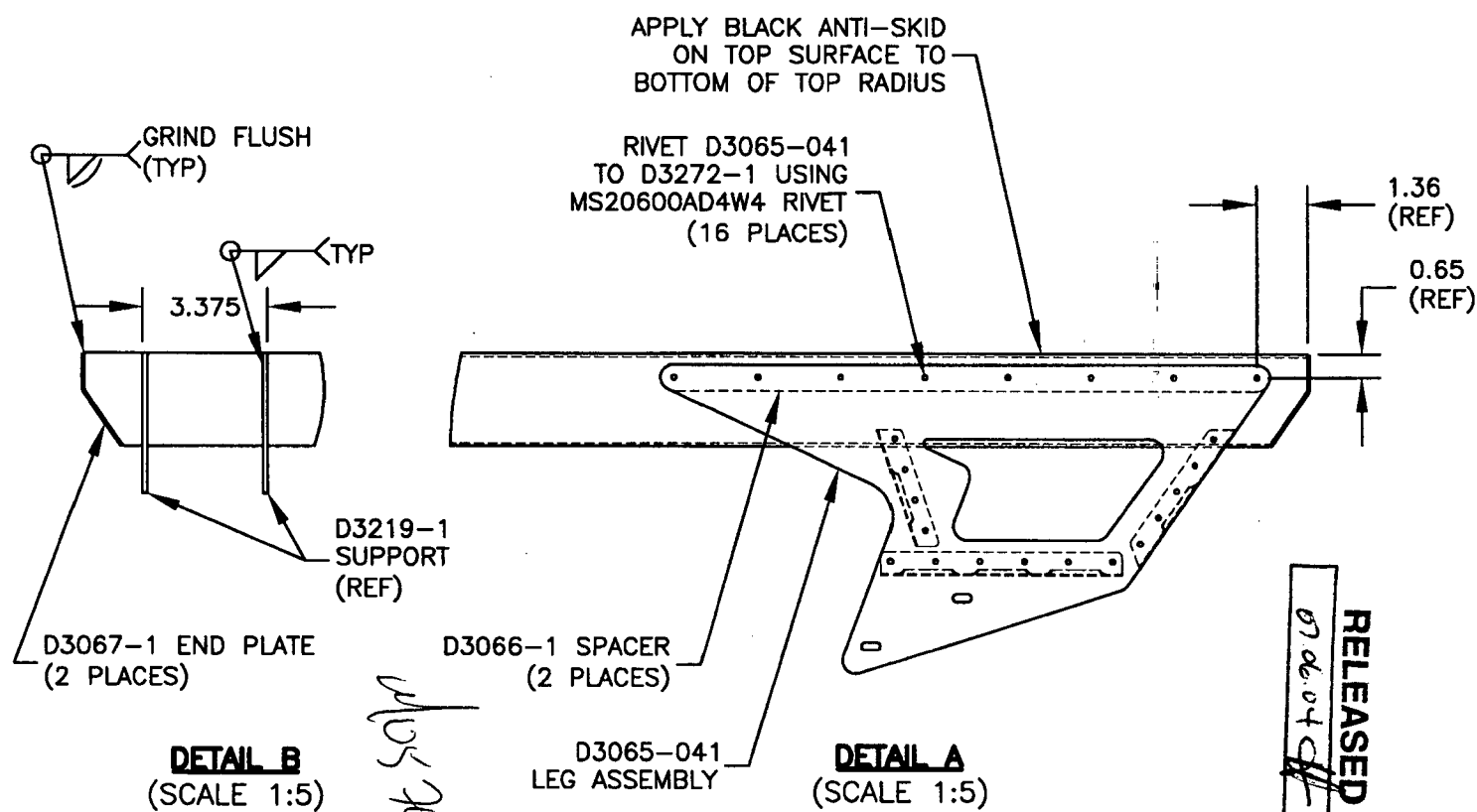
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DART

DESIGN	00	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



WPS 2415

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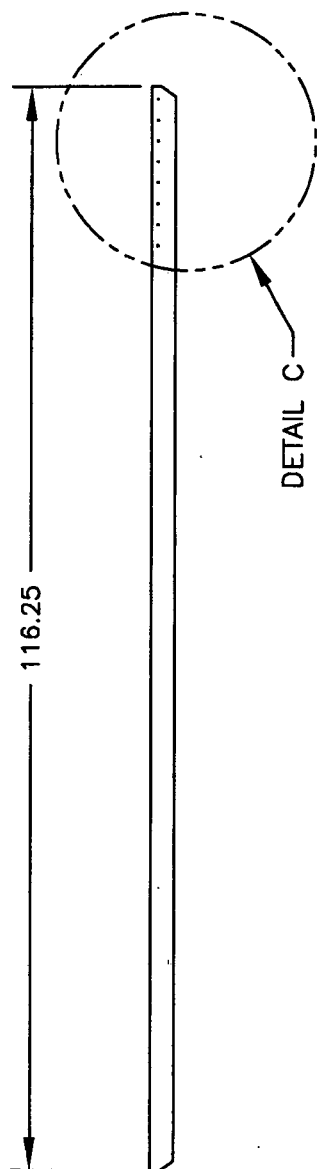
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DESIGN <i>9P</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

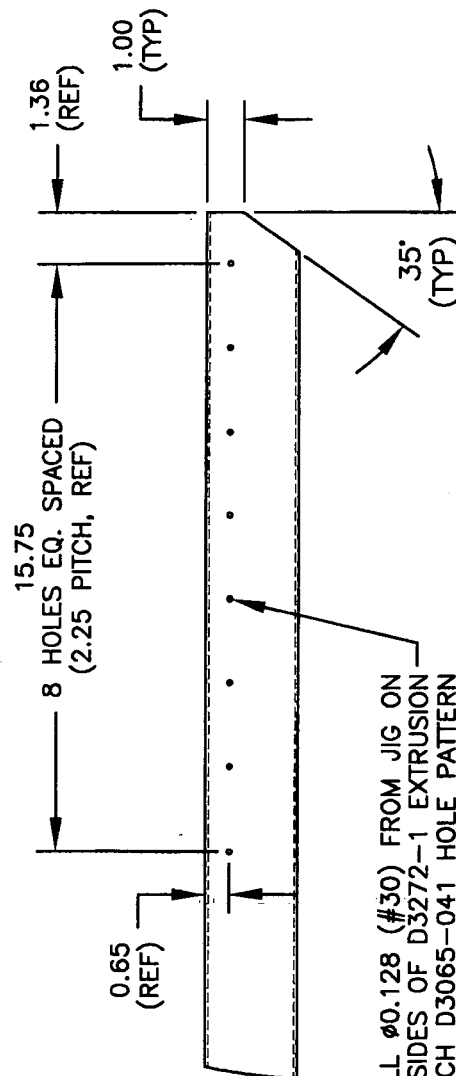
RELEASED

07.06.04



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

*no
studs*

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
								D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-31-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries